

DQA:

Date: 16.04.14



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ☒

Date: 16/03/15

Work Order update only ☐

Work Order: 141029		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. D2939-2BL		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐				
NCR No. 16-5653		Scrap ☐		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐				
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐				
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐					
Date: 16-03-01		Step #: 100		QTY Effective: 1			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition			DAS 9 16-03-01				
piece move in jig while Machining, cant get dimension 0.235 0.240 LC → Part from jig Part from jig Forgot to Remove Section of the jig with obstructed piece to move				Replaced M135956 changes been made in Folio note as			Completed By 16-03-15 Lead hand / Supervisor Approval Verification 16/03/01				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☒ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☒ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☒ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐						Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER: ☐											

Work Order ID 141029

141029

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Tuesday, January 26, 2016 3:19:00 PM

Item ID: D2939-2BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 1/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 14 9-39
130						10	0		16/03/02
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10	0	16-3-2	
HandFinish	Memo	0.01							
Hand Finishing									
150	Spray Painting per QSI005 4.2	0.00							DAS 41 9-89
150						10			16-3-7
SprayPaint	Memo	0.00							
Spray Painting	** MASK ALL HOLES AS PER PAR16-484***								
	SPRAY PAINT BLUE								
	BATCH: _____								
	Prime 134188								
	Paint 134120								
	Clear 129058								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐						

Work Order ID 141029

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141029

Page 3

Item ID: D2939-2BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 1/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
160						10			
QC	Memo	0.00							MAR 08 2016
Quality Control									
170	Identify as per dwg & Stock Location: <i>391</i>	0.00							
170						10			
Packaging	Memo	0.00							MAR 08 2016
Packaging									DAS 6 9-89
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							MAR 08 2016
Quality Control									

MC5 MAR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 141029

141029

Parent Item: D2939-2BL

***D2939-2BL ***

Parent Item Name: Saddle RH In, 206

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
 IPP Rev:C As per Rev C 07-03-19 JLM IPP REV:D 15.10.09
 ADDED BL DD VERF:JLM IPP REV:E 16.01.22 PAR16-
 484 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	62.0000	1	4			

D6101-001

Saddle Billet

M.P.
1/26/2016

Location	Loc Qty	Loc Code
MAT042	62	
132708	14	3
135956	34	7
137755	14	

+1 M135956 ————— 1

DQA: _____ Date: _____

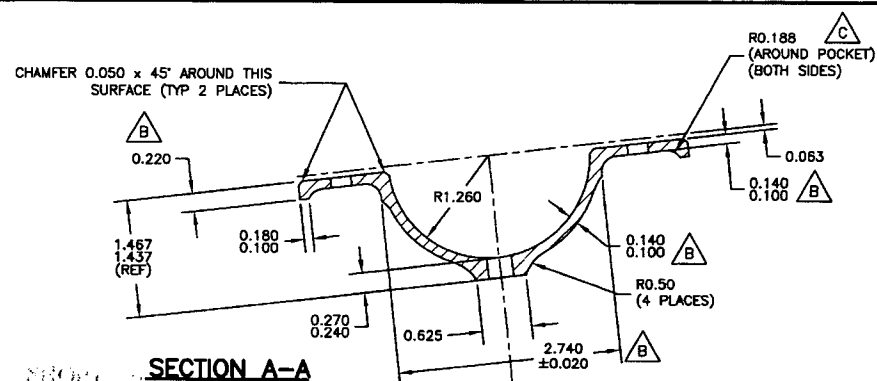


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

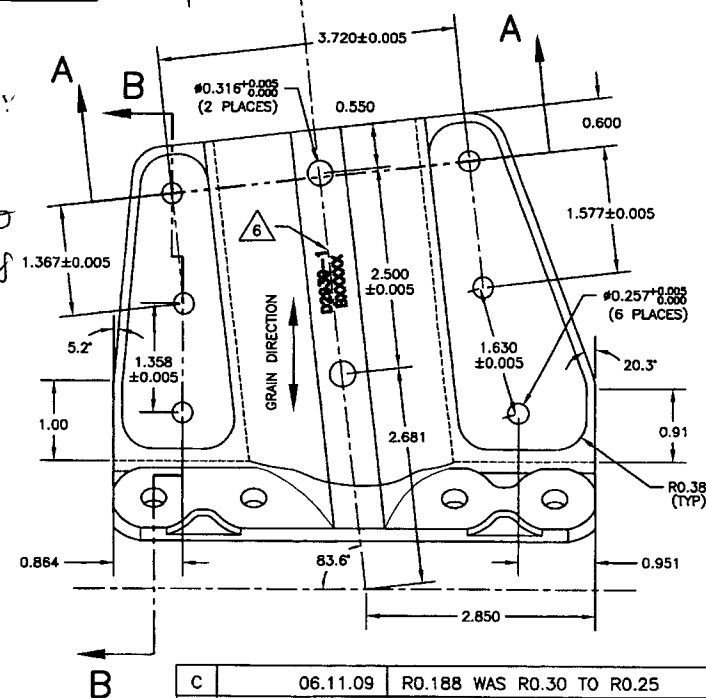
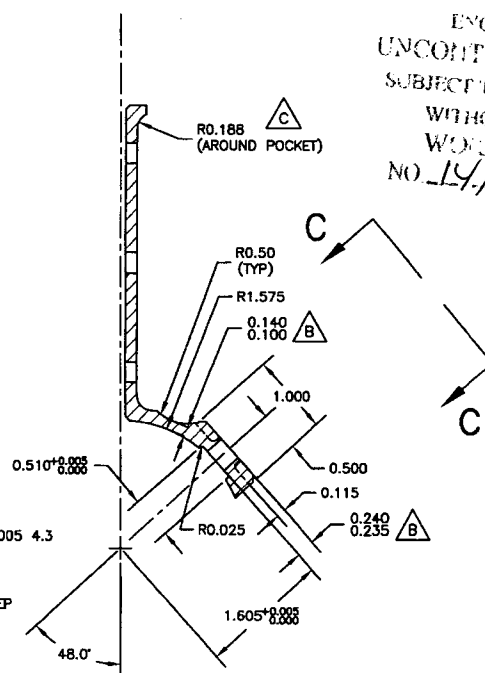
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

SECTION 1
REPAIR TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A FURTHER
WITHOUT NOTICE
WORK ORDER
NO. 14/10.29 MLO



1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D0191-001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SECTION B-B

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2939
DATE 06.11.09		TITLE SADDLE INSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLEVUE, WA

DRAWING NO.	REV. C
D2939	SHEET 1 OF

TITLE	SCALE
-------	-------

SADDLE INSIDE

DART AEROSPACE LTD		Work Order:	141029
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.125	0.126	0.126	0.126	0.126
B	0.100	0.140		0.125	0.126	0.126	0.126	0.126
C	0.100	0.140		0.110	0.112	0.113	0.114	0.115
D	0.210	0.230		0.223	0.222	0.223	0.223	0.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.258	0.258	0.258	0.258	0.258
L	0.312	0.317		0.314	0.314	0.314	0.314	0.314
M	0.235	0.240		0.236	0.235	0.236	0.236	0.236
N	0.100	0.140		0.120	0.121	0.121	0.121	0.122
O	0.540	0.560		0.548	0.548	0.549	0.548	0.550
P	0.490	0.510		0.493	0.499	0.499	0.499	0.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		0.252	0.252	0.252	0.251	0.252
T	0.100	0.180		0.140	0.140	0.140	0.140	0.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.317	0.317	0.317	0.317	0.317
X	1.250	1.270		1.261	1.261	1.261	1.261	1.261
Y	1.565	1.585		1.578	1.576	1.576	1.576	1.576
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
Accept/Reject				✓	✓	✓	✓	✓

Measured by:	<i>[Signature]</i>	Date:	14/02/25
Audited by:	DAS	Date:	16/03/02
Prototype Approval:	14 9-23 N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 141029	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	# 6	# 7	# 8	# 9	# 10
A	0.100	0.140		0.126	0.126	0.126	0.126	0.126
B	0.100	0.140		0.126	0.126	0.126	0.126	0.126
C	0.100	0.140		0.114	0.113	0.114	0.114	0.114
D	0.210	0.230		0.223	0.221	0.221	0.222	0.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.258	0.258	0.258	0.258	0.258
L	0.312	0.317		0.314	0.314	0.314	0.314	0.314
M	0.235	0.240		0.236	0.235	0.235	0.236	0.236
N	0.100	0.140		0.121	0.121	0.121	0.121	0.121
O	0.540	0.560		0.549	0.549	0.548	0.548	0.548
P	0.490	0.510		0.498	0.500	0.498	0.500	0.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		0.252	0.251	0.251	0.252	0.252
T	0.100	0.180		0.140	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.317	0.317	0.317	0.317	0.317
X	1.250	1.270		1.261	1.261	1.261	1.261	1.261
Y	1.565	1.585		1.576	1.576	1.576	1.576	1.576
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: B.A.	DAS 08
Audited by:	DAS 9-89
Prototype Approval:	9-30 N/A

Date: 16/02/26
Date: 16/03/02
Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



Part Number: D2939-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 141029

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
1	0.3120	+0.0050/0.0000	0.3121	0.3132	0.3133	0.3134	0.3130
2	0.5000	+0.0050/-0.0050	0.5003	0.4950	0.4983	0.5001	0.4995
3	1.2500	+0.0050/-0.0050	1.2494	1.2495	1.2499	1.2499	1.2500
4	2.5000	+0.0050/-0.0050	2.5004	2.5008	2.5018	2.4998	2.4999
5	1.2500	+0.0050/-0.0050	1.2490	1.2494	1.2477	1.2494	1.2494
6	6.0000	+0.0100/-0.0100	6.0004	5.9994	6.0000	6.0002	6.0002
D7	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
D8	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
9	1.4520	+0.0150/-0.0150	1.4538	1.4520	1.4531	1.4532	1.4535
10	0.2200	+0.0100/-0.0100	0.2254	0.2238	0.2248	0.2254	0.2251
D11	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D12	0.120	+0.020/-0.020	0.123	0.127	0.125	0.124	0.125
13	1.2600	+0.0100/-0.0100	1.2584	1.2582	1.2582	1.2582	1.2583
14	0.0630	+0.0100/-0.0100	0.0582	0.0598	0.0595	0.0590	0.0587
15	0.1200	+0.0100/-0.0100	0.1249	0.1238	0.1243	0.1246	0.1247
D16	0.120	+0.020/-0.020	0.123	0.125	0.125	0.124	0.125
D17	2.740	+0.020/-0.020	2.740	2.740	2.740	2.740	2.740
D18	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D19	0.255	+0.015/-0.015	0.251	0.252	0.251	0.251	0.251
20	0.3160	+0.0050/0.0000	0.3165	0.3164	0.3161	0.3161	0.3161
21	3.7200	+0.0050/-0.0050	3.7187	3.7186	3.7187	3.7190	3.7182
22	0.5500	+0.0100/-0.0100	0.5507	0.5493	0.5505	0.5497	0.5510
23	0.6000	+0.0100/-0.0100	0.5994	0.5975	0.5989	0.5989	0.5993
24	1.5770	+0.0050/-0.0050	1.5782	1.5775	1.5770	1.5769	1.5773
25	0.2570	+0.0050/0.0000	0.2581	0.2578	0.2577	0.2577	0.2580
26	2.5000	+0.0050/-0.0050	2.5005	2.4998	2.4995	2.5002	2.5001
27	1.6300	+0.0050/-0.0050	1.6298	1.6305	1.6301	1.6298	1.6306
28	20.3000	+0.5000/-0.5000	20.2529	20.2779	20.2569	20.2484	20.2579
29	0.9510	+0.0100/-0.0100	0.9536	0.9517	0.9528	0.9534	0.9534
30	2.8500	+0.0100/-0.0100	2.8513	2.8498	2.8508	2.8515	2.8509
31	2.6810	+0.0100/-0.0100	2.6768	2.6793	2.6779	2.6792	2.6775
32	83.6000	+0.5000/-0.5000	83.5611	83.5573	83.5564	83.5600	83.5577

Measured by:
Mathieu Lamarche

Date:
2016-3-2

Audited by:

Date:



Part Number: D2939-2	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 141029

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
33	0.8640	+0.0100/-0.0100	0.8631	0.8640	0.8635	0.8629	0.8632
34	1.3580	+0.0050/-0.0050	1.3588	1.3592	1.3585	1.3587	1.3596
35	5.2000	+0.5000/-0.5000	5.1686	5.1830	5.1682	5.1741	5.1604
36	1.3670	+0.0050/-0.0050	1.3675	1.3668	1.3677	1.3666	1.3673
D37	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
38	1.5750	+0.0100/-0.0100	1.5703	1.5705	1.5698	1.5717	1.5707
D39	0.120	+0.020/-0.020	0.112	0.112	0.110	0.112	0.110
D40	1.000	+0.010/-0.010	1.004	1.004	1.004	1.003	1.003
41	0.5000	+0.0100/-0.0100	0.4997	0.4994	0.4995	0.4991	0.4995
42	0.1150	+0.0100/-0.0100	0.1140	0.1141	0.1145	0.1148	0.1146
D43	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	0.238
44	1.6050	+0.0050/0.0000	1.6050	1.6074	1.6060	1.6075	1.6052
Ang45	48.000	+0.500/-0.500	47.925	47.902	47.961	47.948	47.925
D46	0.510	+0.005/0.000	0.513	0.513	0.513	0.513	0.514
47	0.0630	+0.0100/-0.0100	0.0592	0.0595	0.0601	0.0610	0.0595

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Mathieu Lamarche

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2016-3-2

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Part Number: D2939-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 141029

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
1	0.3120	+0.0050/0.0000	0.3132	0.3134	0.3134	0.3129	0.3132
2	0.5000	+0.0050/-0.0050	0.4971	0.4980	0.4980	0.4985	0.4979
3	1.2500	+0.0050/-0.0050	1.2500	1.2500	1.2502	1.2505	1.2501
4	2.5000	+0.0050/-0.0050	2.5002	2.5005	2.5000	2.5005	2.5002
5	1.2500	+0.0050/-0.0050	1.2493	1.2492	1.2490	1.2489	1.2496
6	6.0000	+0.0100/-0.0100	6.0000	6.0002	6.0004	6.0005	6.0000
D7	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
D8	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
9	1.4520	+0.0150/-0.0150	1.4524	1.4526	1.4518	1.4536	1.4532
10	0.2200	+0.0100/-0.0100	0.2237	0.2240	0.2233	0.2252	0.2248
D11	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D12	0.120	+0.020/-0.020	0.124	0.123	0.124	0.123	0.123
13	1.2600	+0.0100/-0.0100	1.2580	1.2581	1.2582	1.2582	1.2582
14	0.0630	+0.0100/-0.0100	0.0592	0.0594	0.0601	0.0590	0.0589
15	0.1200	+0.0100/-0.0100	0.1225	0.1224	0.1220	0.1236	0.1232
D16	0.120	+0.020/-0.020	0.124	0.123	0.124	0.123	0.124
D17	2.740	+0.020/-0.020	2.740	2.740	2.740	2.740	2.740
D18	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D19	0.255	+0.015/-0.015	0.251	0.251	0.252	0.252	0.252
20	0.3160	+0.0050/0.0000	0.3162	0.3162	0.3160	0.3161	0.3164
21	3.7200	+0.0050/-0.0050	3.7189	3.7186	3.7189	3.7186	3.7191
22	0.5500	+0.0100/-0.0100	0.5510	0.5509	0.5511	0.5510	0.5497
23	0.6000	+0.0100/-0.0100	0.5988	0.5983	0.5994	0.6010	0.5982
24	1.5770	+0.0050/-0.0050	1.5774	1.5778	1.5775	1.5774	1.5774
25	0.2570	+0.0050/0.0000	0.2570	0.2580	0.2578	0.2575	0.2577
26	2.5000	+0.0050/-0.0050	2.4997	2.5000	2.5003	2.4999	2.4999
27	1.6300	+0.0050/-0.0050	1.6326	1.6302	1.6303	1.6302	1.6297
28	20.3000	+0.5000/-0.5000	20.2623	20.2511	20.2600	20.3018	20.2638
29	0.9510	+0.0100/-0.0100	0.9514	0.9527	0.9521	0.9526	0.9527
30	2.8500	+0.0100/-0.0100	2.8507	2.8509	2.8512	2.8509	2.8509
31	2.6810	+0.0100/-0.0100	2.6779	2.6787	2.6768	2.6780	2.6774
32	83.6000	+0.5000/-0.5000	83.5549	83.5554	83.5582	83.5552	83.5564

Measured by:
Mathieu Lamarche

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2016-3-2

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Part Number: D2939-2	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 141029

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
33	0.8640	+0.0100/-0.0100	0.8647	0.8636	0.8643	0.8641	0.8638
34	1.3580	+0.0050/-0.0050	1.3594	1.3593	1.3586	1.3586	1.3588
35	5.2000	+0.5000/-0.5000	5.1592	5.1575	5.1554	5.1591	5.1598
36	1.3670	+0.0050/-0.0050	1.3673	1.3680	1.3685	1.3672	1.3664
D37	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
38	1.5750	+0.0100/-0.0100	1.5707	1.5718	1.5701	1.5710	1.5692
D39	0.120	+0.020/-0.020	0.113	0.112	0.114	0.112	0.112
D40	1.000	+0.010/-0.010	1.004	1.004	1.006	1.004	1.004
41	0.5000	+0.0100/-0.0100	0.4994	0.4992	0.4991	0.4986	0.4995
42	0.1150	+0.0100/-0.0100	0.1145	0.1148	0.1149	0.1144	0.1145
D43	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	0.238
44	1.6050	+0.0050/0.0000	1.6064	1.6072	1.6052	1.6051	1.6050
Ang45	48.000	+0.500/-0.500	47.905	47.912	47.917	47.909	47.932
D46	0.510	+0.005/0.000	0.514	0.514	0.514	0.513	0.513
47	0.0630	+0.0100/-0.0100	0.0604	0.0609	0.0606	0.0603	0.0592

Measured by:
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